

Work Order ID 73163

Friday, August 26, 2011 7:12:24 AM



Page 1

Item ID: D3639-2

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-08-29

Tooling:

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3639	Rev A

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-8-31

8

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B11-8-31

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

8 u/08/31

(XE)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3639	0.00 0.00		SI 1168/01		(3)			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8160961		(2)			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				x 8		11/09/08	M-L

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 6 11 11/09/06

180

Identify as per dwg & Stock Location: ST 244

0.00



Packaging

Memo

0.00

Packaging

8x 11-09-06

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/06

MF

11-09-06

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Picklist Print

Friday, August 26, 2011 7:12:21 AM

Page 1

Work Order ID: 73163

Parent Item: D3639-2

Parent Item Name: Doubler





Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B
remove c'sink DD 10.04.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	95.9000	0.239	1.509474	2.		
											11-8-31		
				<u>Location</u>				<u>Loc Qty</u>					
				MAT22				95.9					
				117684				95.9		117684			

8

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DART AEROSPACE LTD		Work Order: 73163
Description: Doubler		Part Number: D3639-2
Inspection Dwg: D3639	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.627	>		V B02	
Ø0.191	+0.005/-0.001	.193	>		V	
Ø0.098	+0.004/-0.001	.100	>		V	
0.69	+/-0.030	.693	>		V	
1.59	+/-0.030	1.589	>		V	
2.49	+/-0.030	2.489	>		V	
3.39	+/-0.030	3.388	>		V	
3.990	+/-0.010	3.993	>		V	
4.990	+/-0.010	4.990	>		V	
5.19	+/-0.030	5.19	>		V	
6.99	+/-0.030	6.987	>		V	
8.64	+/-0.030	8.647	x		PROWJ02	
0.45	+/-0.030	.455	>		V	
0.710	+/-0.010	.707	>		V	
2.000	+/-0.010	1.999	>		V	
2.75	+/-0.030	2.756	>		V	
3.55	+/-0.030	3.551	>		V	
4.00	+/-0.030	4.008	>		V	
2.000	+/-0.010	2.000	>		V	
2.590	+/-0.010	2.588	x		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-8-31	Date: 11/08/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	

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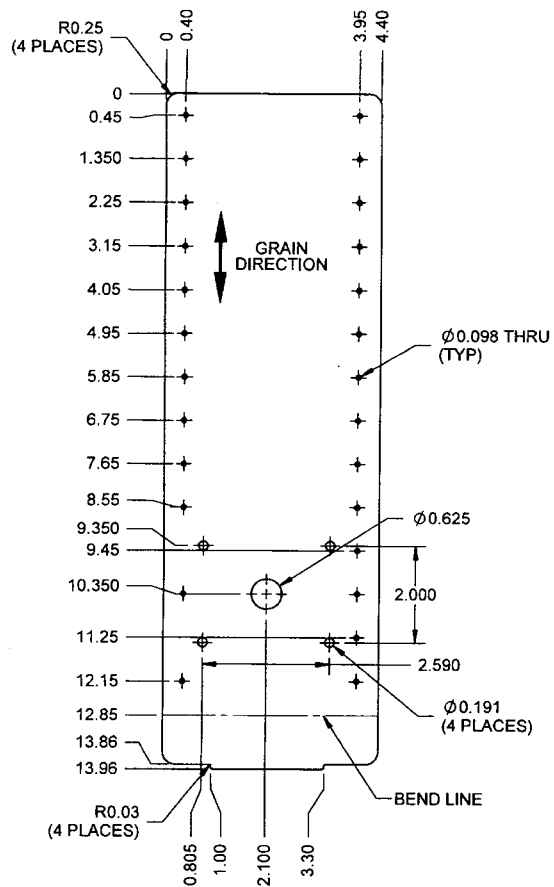
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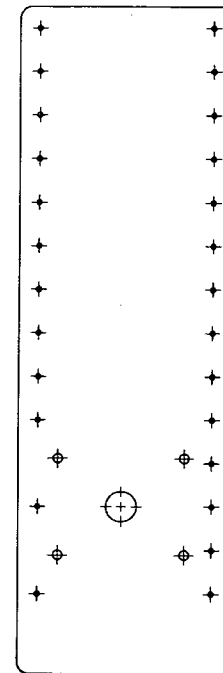
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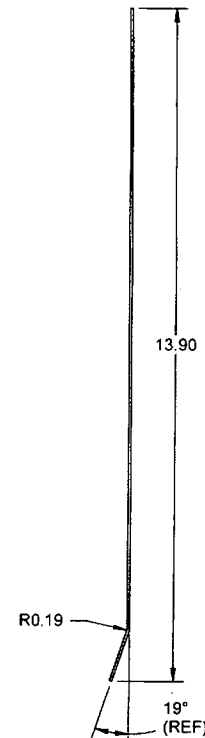
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D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)



73163

RELEASED
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	B	D3639	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	#	DOUBLER	2:5
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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